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3. The process of claim 1 wherein the polymer support comprises a polymer selected from the group consisting of polyamide, polyimide, polycarbonate, polyurea, and polyester.

4. The process of claim 1 wherein the polymer support comprises a polymer selected from the group consisting of polyethylene imine, polyaminostyrene, sulfonated polystyrene, polyvinyl pyridine, and a salt of polyacrylic acid.

5. The process of claim 1 wherein the polymer support comprises polystyrene.

6. The process of claim 1 wherein the polymer support comprises sulfonated polystyrene.

7. The process of claim 1 wherein the polymer support comprises polyvinyl pyridine.

8. The process of claim 1 wherein the polymer support comprises polystyrene substituted with dimethylamine groups.

9. The process of claim 1 wherein the catalyst further comprises a hydrophobic electroactive molecular species.

10. The process of claim 1 wherein the N-substituted N-(phosphonomethyl)glycine reactant is combined with oxygen in the presence of the catalyst and 2,2,6,6-tetramethyl piperidine N-oxide.

11. The process of claim 1 wherein the catalyst further comprises a compound selected from the group consisting of triphenylmethane; N-hydroxyphthalimide; 5,10,15,20-

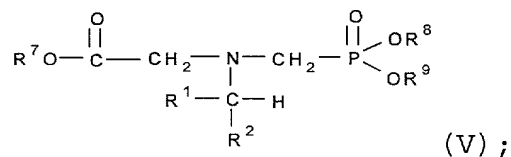
5 tetrakis(pentafluorophenyl)-21H,23H-porphine iron (III)
chloride; 2,4,7-trichlorofluorene; triarylamine; 2,2,6,6-
tetramethyl piperidine N-oxide; 5,10,15,20-tetraphenyl-
21H,23H-porphine iron(III) chloride; 4,4'-
difluorobenzophenone; 5,10,15,20-tetraphenyl-21H,23H
10 porphine nickel(II); and phenothiazine.

12. The process of claim 1 wherein the
catalyst further comprises a triarylamine.

13. The process of claim 1 wherein the
catalyst further comprises tris(4-bromophenyl)amine.

14. The process of claim 1 wherein the
catalyst further comprises N,N'-bis-(3-methylphenyl)-
N,N'-diphenyl benzidine.

15. A process for the preparation of N-
(phosphonomethyl)glycine, a salt of N-
(phosphonomethyl)glycine, or an ester of N-
(phosphonomethyl)glycine, the process comprising
5 combining an N-substituted N-(phosphonomethyl)glycine
reactant with oxygen in the presence of a catalyst
comprising a noble metal and a promoter,
wherein
the N-substituted N-(phosphonomethyl)glycine
10 reactant has formula (V):



15 R^1 and R^2 are independently selected from the group
consisting of hydrogen, halogen, $-\text{PO}_3\text{R}^{12}\text{R}^{13}$, $-\text{SO}_3\text{R}^{14}$, $-\text{NO}_2$,
hydrocarbyl, and substituted hydrocarbyl other than
 $-\text{CO}_2\text{R}^{15}$;

20 R^7 , R^8 , R^9 , R^{12} , R^{13} , R^{14} , and R^{15} are independently
selected from the group consisting of hydrogen,
hydrocarbyl, substituted hydrocarbyl, and an
agronomically acceptable cation;
the promoter comprises a metal selected from the
group consisting of aluminum, ruthenium, osmium, indium,
gallium, tantalum, tin, and antimony; and
at least about 0.05% by weight of the catalyst
consists of the promoter.

16. The process of claim 15 wherein the
promoter comprises indium.

17. The process of claim 15 wherein the
promoter comprises gallium.

18. The process of claim 15 wherein the
promoter comprises ruthenium.

19. The process of claim 15 wherein the
promoter comprises osmium.

5 20. The process of claim 15 wherein R^1 and R^2
are independently selected from the group consisting of
hydrogen, hydrocarbyl, and substituted hydrocarbyl other
than $-\text{CO}_2\text{R}^{15}$; and R^7 , R^8 , and R^9 are independently selected
from the group consisting of hydrogen and an
agronomically acceptable cation.

21. The process of claim 15 wherein the noble metal and promoter are on a support.

22. The process of claim 21 wherein the support comprises graphitic carbon.

23. The process of claim 21 wherein the support comprises a polymer.

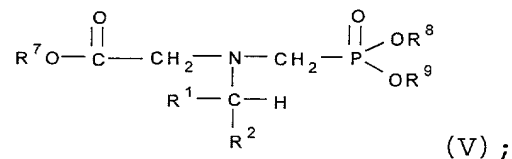
24. A process for the preparation of N-(phosphonomethyl)glycine, a salt of N-(phosphonomethyl)glycine, or an ester of N-(phosphonomethyl)glycine, the process comprising:

5 contacting a surface of a carbon support with an oxidizing agent;

 depositing a noble metal onto the oxidized surface to form a carbon-supported oxidation catalyst; and

10 combining an N-substituted N-(phosphonomethyl)glycine reactant with oxygen in the presence of the carbon-supported oxidation catalyst,

 wherein the N-substituted N-(phosphonomethyl)glycine reactant has formula (V):



15 R¹ and R² are independently selected from the group consisting of hydrogen, halogen, -PO₃R¹²R¹³, -SO₃R¹⁴, -NO₂, hydrocarbyl, and substituted hydrocarbyl other than

-CO₂R¹⁵; and R⁷, R⁸, R⁹, R¹², R¹³, R¹⁴, and R¹⁵ are
independently selected from the group consisting of
20 hydrogen, hydrocarbyl, substituted hydrocarbyl, and an
agronomically acceptable cation.

25. The process of claim 24 wherein the
oxidizing agent comprises H₂O₂.

26. The process of claim 24 wherein (a) the
carbon-supported oxidation catalyst further comprises a
promoter, and (b) at least about 0.05% by weight of the
catalyst consists of the promoter.

27. The process of claim 26 wherein the
promoter comprises indium.

28. The process of claim 26 wherein the
promoter comprises gallium.

29. The process of claim 26 wherein the
promoter comprises ruthenium.

30. The process of claim 26 wherein the
promoter comprises osmium.

31. A process for the preparation of N-
(phosphonomethyl)glycine, a salt of N-
(phosphonomethyl)glycine, or an ester of N-
(phosphonomethyl)glycine, the process comprising:
5 combining an N-substituted N-
(phosphonomethyl)glycine mixture comprising an N-
substituted N-(phosphonomethyl)glycine reactant with

(phosphonomethyl)glycine reactant initially in the N-substituted N-(phosphonomethyl)glycine mixture has been
5 consumed, N-(phosphonomethyl)glycine, the salt of N-(phosphonomethyl)glycine, or the ester of N-(phosphonomethyl)glycine is separated from the N-(phosphonomethyl)glycine mixture to recover the separated
10 N-(phosphonomethyl)glycine, salt of N-(phosphonomethyl)glycine, or ester of N-(phosphonomethyl)glycine and form the residual mixture.

33. The process of claim 32 wherein N-(phosphonomethyl)glycine, the salt of N-(phosphonomethyl)glycine, or the ester of N-(phosphonomethyl)glycine is separated from the N-
5 (phosphonomethyl)glycine mixture when from about 50 to about 90% of the N-substituted N-(phosphonomethyl)glycine reactant initially in the N-substituted N-(phosphonomethyl)glycine mixture has been consumed.

34. The process of claim 32 wherein N-(phosphonomethyl)glycine, the salt of N-(phosphonomethyl)glycine, or the ester of N-(phosphonomethyl)glycine is separated from the N-
5 (phosphonomethyl)glycine mixture when from about 50 to about 80% of the N-substituted N-(phosphonomethyl)glycine reactant initially in the N-substituted N-(phosphonomethyl)glycine mixture has been consumed.

35. The process of claim 32 wherein N-(phosphonomethyl)glycine, the salt of N-(phosphonomethyl)glycine, or the ester of N-(phosphonomethyl)glycine is separated from the N-

5 (phosphonomethyl)glycine mixture when from about 50 to about 70% of the N-substituted N-(phosphonomethyl)glycine reactant initially in the N-substituted N-(phosphonomethyl)glycine mixture has been consumed.

36. The process of claim 31 wherein the residual mixture is divided into a recycle mixture and a waste mixture by being pressurized and contacted with a membrane which selectively passes a contaminant from the residual mixture while retaining (a) the N-substituted N-(phosphonomethyl)glycine reactant, and (b) N-(phosphonomethyl)glycine, the salt of N-(phosphonomethyl)glycine, or the ester of N-(phosphonomethyl)glycine, wherein

10 the waste mixture comprises any portion of the residual mixture which passes through the membrane; and the recycle mixture (a) comprises any portion of the residual mixture which does not pass through the membrane, and (b) comprises the portion of the residual

15 mixture which is fed back into the oxidation reaction zone.

37. The process of claim 36 wherein the contaminant is a salt.

38. The process of claim 31 wherein the residual mixture is divided into a recycle mixture and a waste mixture by being pressurized and contacted with a membrane having a molecular weight cutoff of less than

5 about 1,000 daltons, wherein

the waste mixture comprises any portion of the residual mixture which passes through the membrane; and

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of undissolved oxygen.

43. A process for the preparation of N-(phosphonomethyl)glycine, a salt of N-(phosphonomethyl)glycine, or an ester of N-(phosphonomethyl)glycine, the process comprising
5 introducing oxygen into a mixture comprising an N-substituted N-(phosphonomethyl)glycine reactant and a noble metal catalyst in a stirred tank reactor,

the oxygen is introduced into the mixture as gas
10 bubbles in a manner such that essentially no gas bubbles
enter a region of the reactor through which an impeller
passes;

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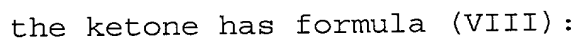


20 R⁷, R⁸, R⁹, R¹², R¹³, R¹⁴, and R¹⁵ are independently
selected from the group consisting of hydrogen,
hydrocarbyl, substituted hydrocarbyl, and an
agronomically acceptable cation.

5 combining an N-substituted N-
(phosphonomethyl)glycine reactant with oxygen in the
presence of a noble metal catalyst in an oxidation
reaction zone to form an oxidation product comprising (a)
a ketone, and (b) N-(phosphonomethyl)glycine, the salt of
10 N-(phosphonomethyl)glycine, or the ester of N-
(phosphonomethyl)glycine;

using the recovered ketone as a starting material to
15 form the N-substituted N-(phosphonomethyl)glycine
reactant; and

wherein the N-substituted N-(phosphonomethyl)glycine reactant has formula (V):



R¹ and R² are independently selected from the group consisting of hydrocarbyl and substituted hydrocarbyl other than -CO₂R¹⁵; and R⁷, R⁸, R⁹, and R¹⁵ are independently selected from the group consisting of
30 hydrogen, hydrocarbyl, substituted hydrocarbyl, and an agronomically acceptable cation.

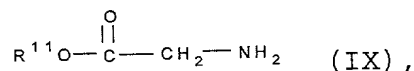
45. The process of claim 44 wherein R⁷, R⁸, and R⁹ are independently selected from the group consisting of hydrogen and an agronomically acceptable cation.

46. The process of claim 44 wherein R¹ is methyl, and R² is selected from the group consisting of methyl and ethyl.

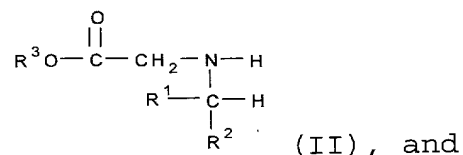
47. The process of claim 44 wherein:
the ketone is combined with H₂ and a glycine reactant in the presence of a metal-containing catalyst to form an N-substituted glycine reactant, and

5 the N-substituted glycine reactant is phosphonomethylated to form the N-substituted N-(phosphonomethyl)glycine reactant,

wherein the glycine reactant has formula (IX):



10 the N-substituted glycine reactant has formula (II):



R^3 and R^{11} are independently selected from the group consisting of hydrogen and an agronomically acceptable cation.

48. The process of claim 47 wherein the metal-containing catalyst comprises a metal selected from the group consisting of platinum and palladium.

49. The process of claim 44 wherein:

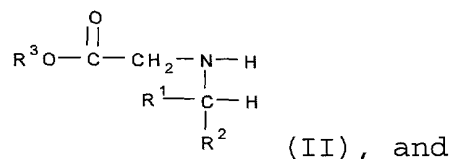
the ketone is combined with H_2 and ammonia in the presence of a metal-containing catalyst to form a primary amine,

5 the primary amine is combined with HCN and a source of CH_2O to form a nitrile,

the nitrile is hydrolyzed to form an N-substituted glycine reactant, and

10 the N-substituted glycine reactant is phosphonomethylated to form the N-substituted N-(phosphonomethyl)glycine reactant,

wherein the N-substituted glycine reactant has formula (II):



15 R^3 is selected from the group consisting of hydrogen and an agronomically acceptable cation.

50. The process of claim 44 wherein:

the ketone is combined with H₂ and ammonia in the presence of a first catalyst comprising a metal to form a primary amine,

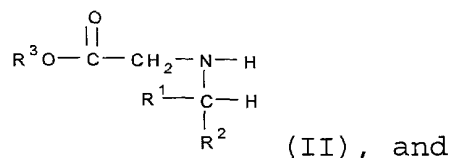
5 the primary amine is converted into an amide,

the amide is combined with CO and a source of CH₂O in the presence of a second catalyst comprising a metal selected from the group consisting of cobalt and palladium to form an N-substituted glycine amide,

10 the N-substituted glycine amide is hydrolyzed to form an N-substituted glycine reactant, and

the N-substituted glycine reactant is phosphonomethylated to form the N-substituted N-(phosphonomethyl)glycine reactant,

15 wherein the N-substituted glycine reactant has formula (II):



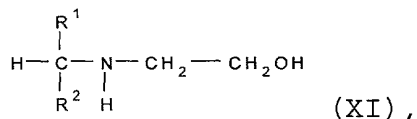
R³ is selected from the group consisting of hydrogen and an agronomically acceptable cation.

51. The process of claim 44 wherein:

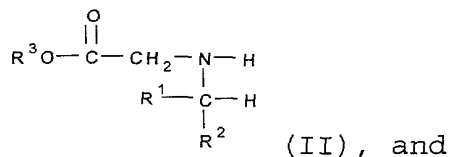
the ketone is combined with H₂ and monoethanolamine in the presence of a metal-containing catalyst to form an N-substituted monoethanolamine,

5 the N-substituted monoethanolamine is combined with a strong base in the presence of a catalyst comprising copper to form an N-substituted glycine reactant, and

the N-substituted glycine reactant is
phosphonomethylated to form the N-substituted N-
10 (phosphonomethyl)glycine reactant,
wherein the N-substituted monoethanolamine has
formula (XI):



the N-substituted glycine reactant has formula (II):



R³ is selected from the group consisting of hydrogen and
an agronomically acceptable cation.

52. The process of claim 51 wherein the base
comprises NaOH.

53. The process of claim 51 wherein the
ketone, monoethanolamine, and H₂ are combined essentially
in the absence of any non-reactive solvent.

54. The process of claim 53 wherein the ketone
is acetone.

55. A process for the preparation of N-
(phosphonomethyl)glycine or a salt thereof, the process
comprising:

converting an N-substituted glycine salt into an N-
5 substituted glycine free acid,

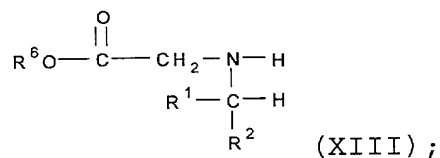
phosphonomethylating the N-substituted glycine free
acid to form an N-substituted N-(phosphonomethyl)glycine,
and

combining the N-substituted N-
10 (phosphonomethyl)glycine or a salt thereof with oxygen in
the presence of a noble metal catalyst in an oxidation
reaction zone,

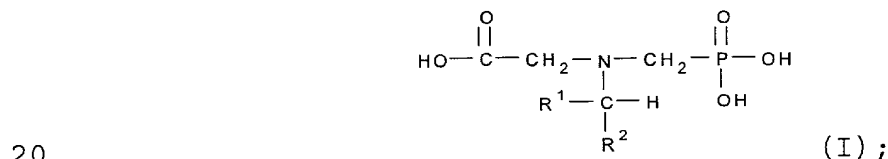
wherein the N-substituted glycine free acid has
formula (XII):



the N-substituted glycine salt has formula (XIII):



the N-substituted N-(phosphonomethyl)glycine has formula
(I):



R¹ and R² are independently selected from the group consisting of hydrogen, halogen, -PO₃R¹²R¹³, -SO₃R¹⁴, -NO₂, hydrocarbyl, and substituted hydrocarbyl other than -CO₂R¹⁵; R⁶ is an agronomically acceptable cation; R¹², R¹³,
25 and R¹⁴ are independently selected from the group consisting of hydrogen, hydrocarbyl, and substituted hydrocarbyl; and R¹⁵ is selected from the group consisting of hydrogen, hydrocarbyl, substituted hydrocarbyl, and an agronomically acceptable cation.

56. The process of claim 55 wherein the N-substituted glycine salt is converted into the N-substituted glycine free acid by contacting a mixture comprising the N-substituted glycine salt with a first
5 side of a cation exchange membrane while simultaneously contacting a second side of the cation exchange membrane with an N-substituted N-(phosphonomethyl)glycine mixture comprising (a) the N-substituted N-(phosphonomethyl)glycine or the salt thereof, and (b) a
10 strong acid having a pK_a of no greater than about 1.0.

57. The process of claim 56 wherein the strong acid comprises H₂SO₄.

58. The process of claim 56 wherein, after being contacted with the second side of the cation exchange membrane, the N-substituted N-(phosphonomethyl)glycine mixture is combined with oxygen
5 in the presence of the noble metal in the oxidation reaction zone.

59. The process of claim 58 wherein R¹ is methyl, and R² is selected from the group consisting of methyl and ethyl.

60. The method of claim 58 wherein the N-substituted N-(phosphonomethyl)glycine mixture does not contain a halogen.

61. The process of claim 55 wherein the N-substituted glycine salt is converted into the N-substituted glycine free acid by contacting a mixture comprising the N-substituted glycine salt with a first
5 side of a cation exchange membrane while simultaneously contacting a second side of the cation exchange membrane with a mixture comprising a strong acid having a pK_a of no greater than about 1.0.

62. The process of claim 55 wherein the N-substituted glycine salt is converted into the N-substituted glycine free acid by a process comprising:
combining PCl₃ and water to form a PCl₃ hydrolysis
5 mixture comprising H₃PO₃ and HCl;
separating HCl from the PCl₃ hydrolysis mixture to form an H₃PO₃-containing mixture and an HCl-containing mixture; and
contacting the HCl-containing mixture with a first
10 side of a cation exchange membrane while simultaneously contacting a second side of the cation exchange membrane with a mixture comprising the N-substituted glycine salt.

63. The method of claim 62 wherein R¹ and R² are hydrogen.

64. A process for the preparation of an N-substituted N-(phosphonomethyl)glycine or a salt thereof, the process comprising:

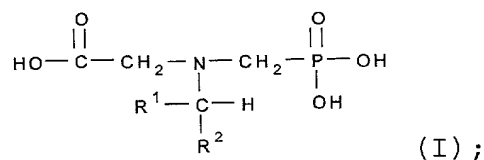
combining a source of H_3PO_3 , a source of CH_2O , and an
5 N-substituted glycine salt in a reaction zone to form a first mixture which comprises (a) the N-substituted N-(phosphonomethyl)glycine or the salt thereof, and (b) a salt precipitate;

separating salt precipitate from the first mixture
10 to form a second mixture which comprises the N-substituted N-(phosphonomethyl)glycine or the salt thereof;

adding a base to the second mixture to precipitate
N-substituted N-(phosphonomethyl)glycine or the salt
15 thereof; and

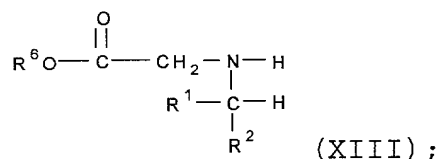
separating the precipitated N-substituted N-(phosphonomethyl)glycine or salt thereof from the second mixture to recover the precipitated N-substituted N-(phosphonomethyl)glycine or salt thereof and form a
20 residual mixture,

wherein the N-substituted N-(phosphonomethyl)glycine has formula (I):



the N-substituted glycine salt has formula (XIII):

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R^1 and R^2 are independently selected from the group consisting of hydrogen, halogen, $-\text{PO}_3\text{R}^{12}\text{R}^{13}$, $-\text{SO}_3\text{R}^{14}$, $-\text{NO}_2$, hydrocarbyl, and substituted hydrocarbyl other than $-\text{CO}_2\text{R}^{15}$; R^6 is an agronomically acceptable cation; R^{12} , R^{13} , and R^{14} are independently selected from the group consisting of hydrogen, hydrocarbyl, and substituted hydrocarbyl; and R^{15} is selected from the group consisting of hydrogen, hydrocarbyl, substituted hydrocarbyl, and an agronomically acceptable cation.

65. The process of claim 64 wherein the source of H_3PO_3 comprises PCl_3 .

66. The process of claim 64 wherein the salt precipitate comprises chlorine.

67. The process of claim 64 wherein R^1 and R^2 are hydrogen.

68. The process of claim 64 wherein R^1 is methyl and R^2 is hydrogen.

69. The process of claim 64 wherein R^1 is methyl and R^2 is selected from the group consisting of methyl and ethyl.

70. The process of claim 64 wherein at least a portion of the residual mixture is recycled to the reaction zone.

71. The process of claim 64 further comprising the preparation of N-(phosphonomethyl)glycine or a salt thereof by a process comprising combining the recovered N-substituted N-(phosphonomethyl)glycine or the salt thereof with oxygen in the presence of a noble metal catalyst.

72. A process for the preparation of an N-substituted N-(phosphonomethyl)glycine or a salt thereof, the process comprising:

combining a source of H_3PO_3 and an N-substituted glycine salt in a reaction zone to form a first mixture which comprises (a) an N-substituted glycine free acid, and (b) a salt precipitate;

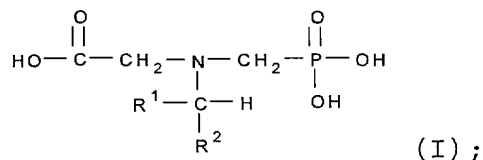
separating salt precipitate from the first mixture to form a second mixture comprising the N-substituted glycine free acid;

adding a source of CH_2O to the second mixture to form a third mixture which comprises the N-substituted N-(phosphonomethyl)glycine or the salt thereof;

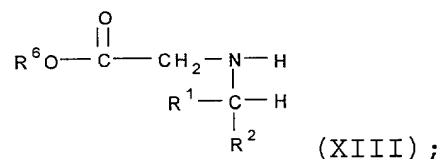
adding a base to the third mixture to precipitate N-substituted N-(phosphonomethyl)glycine or the salt thereof; and

separating precipitated N-substituted N-(phosphonomethyl)glycine or the salt thereof from the third mixture to recover the precipitated N-substituted N-(phosphonomethyl)glycine or salt thereof and form a residual mixture;

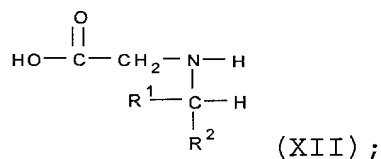
wherein the N-substituted N-(phosphonomethyl)glycine has formula (I):



25 the N-substituted glycine salt has formula (XIII):



the N-substituted glycine free acid has formula (XII):



R¹ and R² are independently selected from the group consisting of hydrogen, halogen, -PO₃R¹²R¹³, -SO₃R¹⁴, -NO₂, hydrocarbyl, and substituted hydrocarbyl other than -CO₂R¹⁵; R⁶ is an agronomically acceptable cation; R¹², R¹³, and R¹⁴ are independently selected from the group consisting of hydrogen, hydrocarbyl, and substituted hydrocarbyl; and R¹⁵ is selected from the group consisting of hydrogen, hydrocarbyl, substituted hydrocarbyl, and an agronomically acceptable cation.

73. The process of claim 72 wherein the source of H₃PO₃ comprises PCl₃.

74. The process of claim 72 wherein the salt precipitate comprises chlorine.

75. The process of claim 72 wherein R¹ and R² are hydrogen.

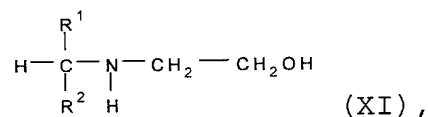
76. The process of claim 72 wherein R¹ is methyl and R² is hydrogen.

77. The process of claim 72 wherein at least a portion of the residual mixture is recycled to the reaction zone.

78. The process of claim 72 further comprising the preparation of N-(phosphonomethyl)glycine or a salt thereof by a process comprising combining the recovered N-substituted N-(phosphonomethyl)glycine or the salt
5 thereof with oxygen in the presence of a noble metal catalyst.

79. A process for the preparation of an N-substituted monoethanolamine, the process comprising combining a ketone, monoethanolamine, and H₂ in the presence of a metal-containing catalyst and essentially
5 in the absence of any non-reactive solvent,

wherein the N-substituted monoethanolamine has formula (XI):



the ketone has formula (VIII):



R^1 and R^2 are independently selected from the group consisting of hydrocarbyl and substituted hydrocarbyl.

80. The process of claim 79 wherein the metal-containing catalyst comprises a metal selected from the group consisting of palladium and platinum.

81. The process of claim 79 wherein the ketone is acetone.

82. An oxidation catalyst comprising a noble metal and an electroactive molecular species.

83. The oxidation catalyst of claim 82 wherein the electroactive molecular species is hydrophobic.

84. The oxidation catalyst of claim 82 wherein the electroactive molecular species has an oxidation potential of at least about 0.3 volts vs. SCE.

85. The oxidation catalyst of claim 82 wherein the electroactive molecular species comprises a compound selected from the group consisting of triphenylmethane; N-hydroxyphthalimide; 2,4,7-trichlorofluorene; tris(4-bromophenyl)amine; 2,2,6,6-tetramethyl piperidine N-oxide; 5,10,15,20-tetraphenyl-21H,23H-porphine iron(III) chloride; 5,10,15,20-tetraphenyl-21H,23H porphine nickel(II); 4,4'-difluorobenzophenone; 5,10,15,20-

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10 tetrakis(pentafluorophenyl)-21H,23H-porphine iron (III)
chloride; and phenothiazine.

86. The oxidation catalyst of claim 82 wherein the electroactive molecular species comprises 2,2,6,6-tetramethyl piperidine N-oxide.

87. The oxidation catalyst of claim 82 wherein the electroactive molecular species comprises a triarylamine.

88. The oxidation catalyst of claim 82 wherein the electroactive molecular species comprises N,N'-bis(3-methylphenyl)-N,N'-diphenyl benzidine.

89. The oxidation catalyst of claim 82 wherein (a) the catalyst further comprises a promoter, and (b) at least about 0.05% by weight of the catalyst consists of the promoter.

90. The oxidation catalyst of claim 89 wherein the promoter comprises a metal selected from the group consisting of aluminum, ruthenium, osmium, indium, gallium, tantalum, tin, and antimony.

91. The oxidation catalyst of claim 82 further comprising a support comprising a material selected from the group consisting of carbon, alumina, silica, titania, zirconia, siloxane, and barium sulfate.

92. The oxidation catalyst of claim 91 wherein the support comprises a material selected from the group

consisting of alumina, silica, titania, zirconia, siloxane, and barium sulfate.

93. The oxidation catalyst of claim 91 wherein the support comprises a material selected from the group consisting of silica, titania, and barium sulfate.

94. The oxidation catalyst of claim 91 wherein the support comprises graphitic carbon.

95. The oxidation catalyst of claim 82 wherein the noble metal is on a support which comprises a polymer.

96. The oxidation catalyst of claim 95 wherein the support comprises a polymer selected from the group consisting of polyamide, polyimide, polycarbonate, polyurea, and polyester.

97. The oxidation catalyst of claim 95 wherein the support comprises a polymer selected from the group consisting of polyethylene imine, polyaminostyrene, sulfonated polystyrene, polyvinyl pyridine, and a salt of polyacrylic acid.

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98. The oxidation catalyst of claim 95 wherein the support comprises polystyrene.

99. The oxidation catalyst of claim 95 wherein the support comprises polystyrene substituted with dimethylamine groups.